

Work Order ID 145073

145073

Page 1

Thursday, May 12, 2016 1:26:28 PM

Item ID: D4682-043 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 5/6/2016 Start Qty: 3.00 Cust Item ID:
 Required Date: 5/18/2016 Req'd Qty: 3.00 Customer:
 Reference: DAS

Approvals: Process Plan: 13 MAY 12 2016 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4682	D								

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg D4682-3

prog rev: D

dwg rev: D

2-Deburr if required

0.33

(4)

DL 16/06/25

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.03

(4)

DL 16/06/25

145073

Thursday, May 12, 2016 1:26:28 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/6/2016 **Start Qty:** 3.00

3

Cust Item ID:

Required Date: 5/18/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

130

QC

Memo

0.06

Quality Control

DAS

38

9-89

JUN 29 2016

0.10

140

Small Fab

Memo

0.57

Small Fab

Form as per dwg D4682

DAS
30
9-89

JUL 11 2016

QC5- Inspect part completeness to step on W/O

0.00

150

OC

Memo

0.06

Quality Control

DAS
38
9-88

JUL 11 2016

Work Order ID 145073

Thursday, May 12, 2016 1:26:28 PM

145073

Page 3

Item ID: D4682-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 5/6/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 5/18/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: 123023 130145	0.00				<u>4</u>			<u>16-07-12</u> <u>JBL</u>
	Memo	2.28							
	1- Weld hardcoat as per dwg and QSI004								
	2- Weld shim to wearplate as per dwg and QSI004 A/R s.s. rod Batch #: 123023								
170 *170* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				<u>(4)</u>	<u>16-07-12</u>		DAS 9 9-89
Quality Control	Memo	0.00							
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00				<u>(4)</u>	<u>16-07-12</u>		DAS 9 9-89
Quality Control	Memo	0.06							

Work Order ID 145073

Thursday, May 12, 2016 1:26:28 PM

145073

Page 4

Item ID: D4682-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 5/6/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 5/18/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* SprayPaint Spray Painting	Memo 1- Apply Rockguard on entire concave surface as per dwg A/R Rockguard Batch: <u>134811</u> 2- Indicate FWD direction as shown using white paint marker(SEE NOTE 11)	0.00 0.21				<u>4</u>			DAS 41 9-89 16-7-12
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.06				<u>(4)</u>			DAS 38 9-89 JUL 13 2016
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: <u>51192</u> Memo	0.00 0.03				<u>4</u>		<u>R</u>	JUL 13 2016

145073

Thursday, May 12, 2016 1:26:28 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/6/2016 **Start Qty:** 3.00 ***3***

Cust Item ID:

Required Date: 5/18/2016 **Req'd Qty:** 3.00 ***3***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

QC21- Final Inspection - Work Order Release

0.00

220

OC

Memo

0.30

Quality Control

DAS
21 JUL 14 2016
9-89

DAS
21 JUL 14 2016
9-89

Picklist Print

Thursday, May 12, 2016 1:26:27 PM

Page 1

Work Order ID: 145073

145073

Parent Item: D4682-043

D4682-043

Parent Item Name: Wearplate Assembly

Start Date: 5/6/2016

Required Date: 5/18/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.14 AS PER DWG REV.B DD VERF:JLM IPP REV:D
14.11.24 AS PER DWG REV.C DD VERF:JLM IPP REV:E 15.06.10
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4682-9		Manufactured	No				Each	14.0000		3			
D4682-9									**				16-07-12
Wearplate Shim													JBC

Location	Loc Qty	Loc Code
WA002 146079	14	
141356	14	

M304S18GA		Purchased	No			110	sf	218.2905	1.31	4.136842			
M304S18GA									**				on 16/06/28
304/316 .050 Sheet													

Location	Loc Qty	Loc Code
MAT020	79.521	
M133328	67.796	
M133587	11.725	
MAT20	128	
M134580	128	
TPI	10.76946	
M134604	10.76946	
134824		

4.5

DQA: _____ Date: _____



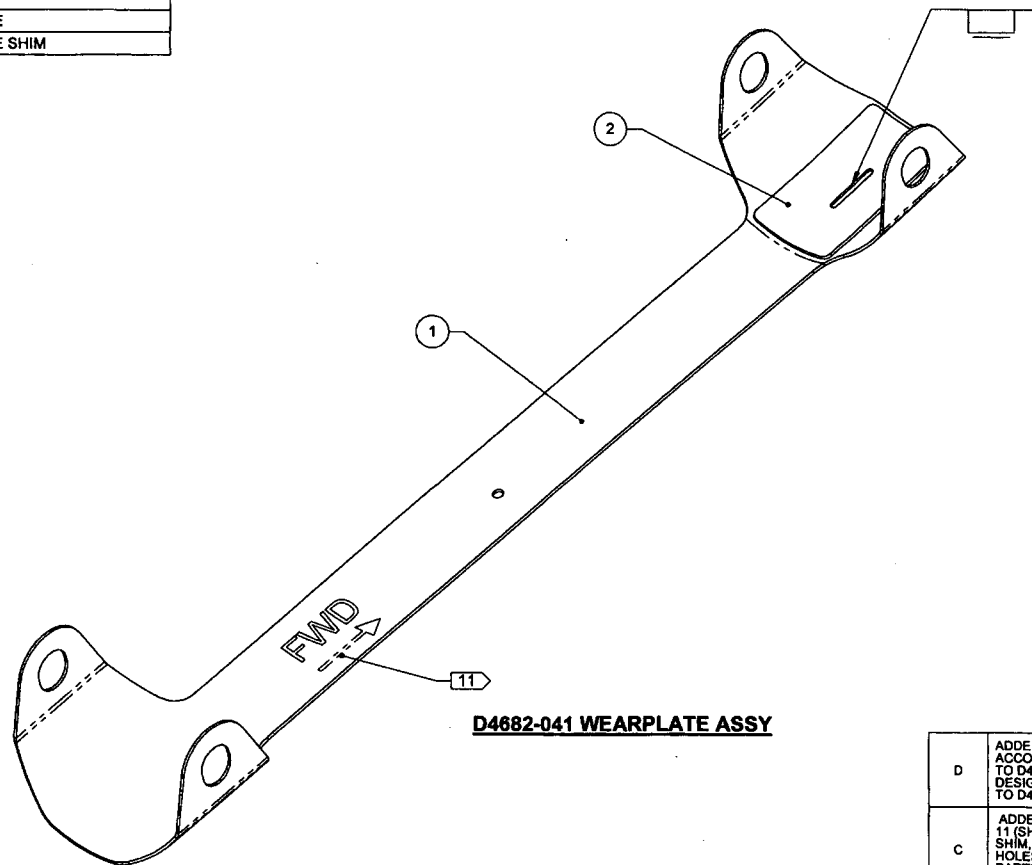
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

ITEM	QTY	P/N	DESCRIPTION
	X	D4682-041	WEARPLATE ASSY
1	1	D4682-1	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM



RELEASED
2015-06-08
ECN 15-551

D4682-041 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.06 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO Ø0.188 AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

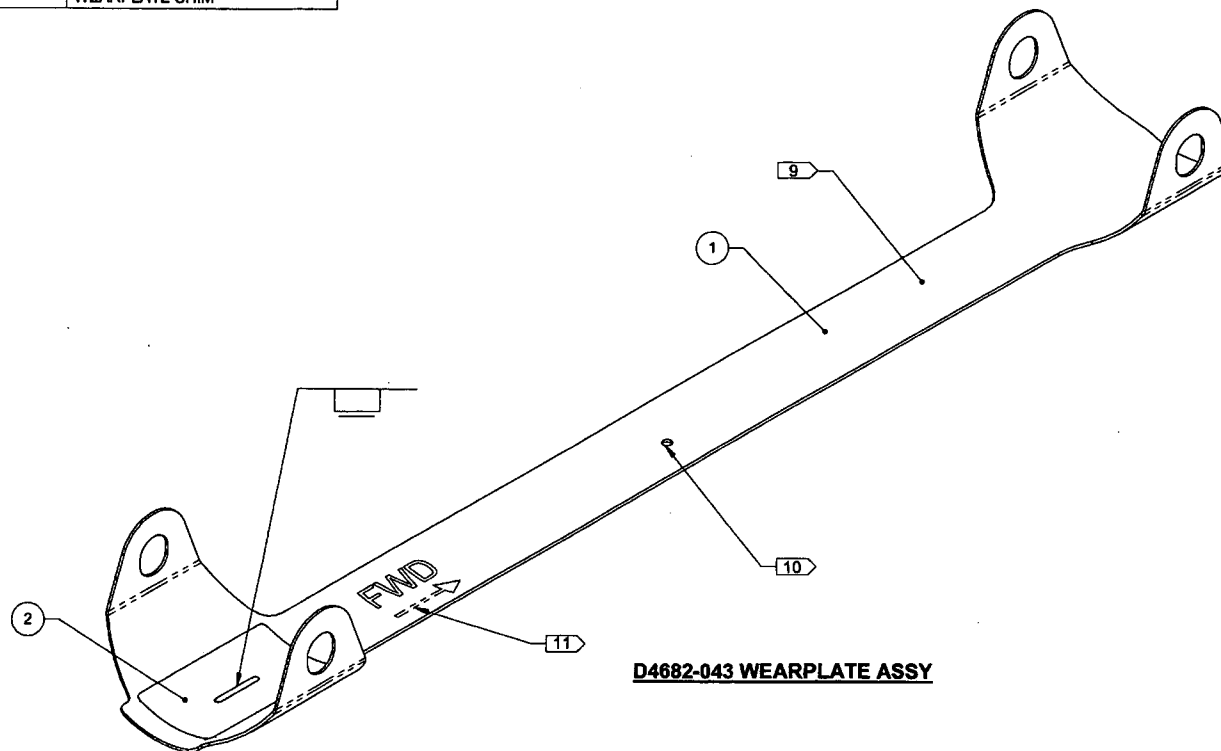
D	ADDED SHT 2, WEARPLATE FORMING MODIFIED TO ACCOMMODATE MATERIAL SPRING BACK, ADD FWD BEND TO D4682-041, MINOR DIM CHANGES, D4682-9 RE-DESIGNED, D4682-11 REMOVED, ADD FWD INDICATION TO D4682-045-7	AP	15.03.24
C	ADDED FWD INDICATION ON D4682-041-043 PER NOTE 11 (SHT 1), D4682-11 SHIM (SHT 8) REPLACED D4769-3 SHIM, VARIOUS DIMENSIONAL CHANGES TO THRU HOLES AND OVERALL DIMENSIONS OF D4682-1-3/-5/-9 PARTS. REFERENCE TO PLUS ONE ROCKGUARD REMOVED.	AP	14.07.29
B	THRU HOLES NOW SLOTS, VARIOUS DIMENSIONAL CHANGES, Ø0.188 HOLE MOVED (B5-3), UPDATED PART WEIGHTS, REMOVED GRAIN DIR ON ALL PARTS D4769-3 WAS D4682-9 ON D4682-041 WEARPLATE ASSY.	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4682	SHEET 1 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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APPROVED

w/o 145073

dm 16/05/03

ITEM	QTY	P/N	DESCRIPTION
	X	D4682-043	WEARPLATE ASSY
1	1	D4682-3	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM



D4682-043 WEARPLATE ASSY

NOTES:

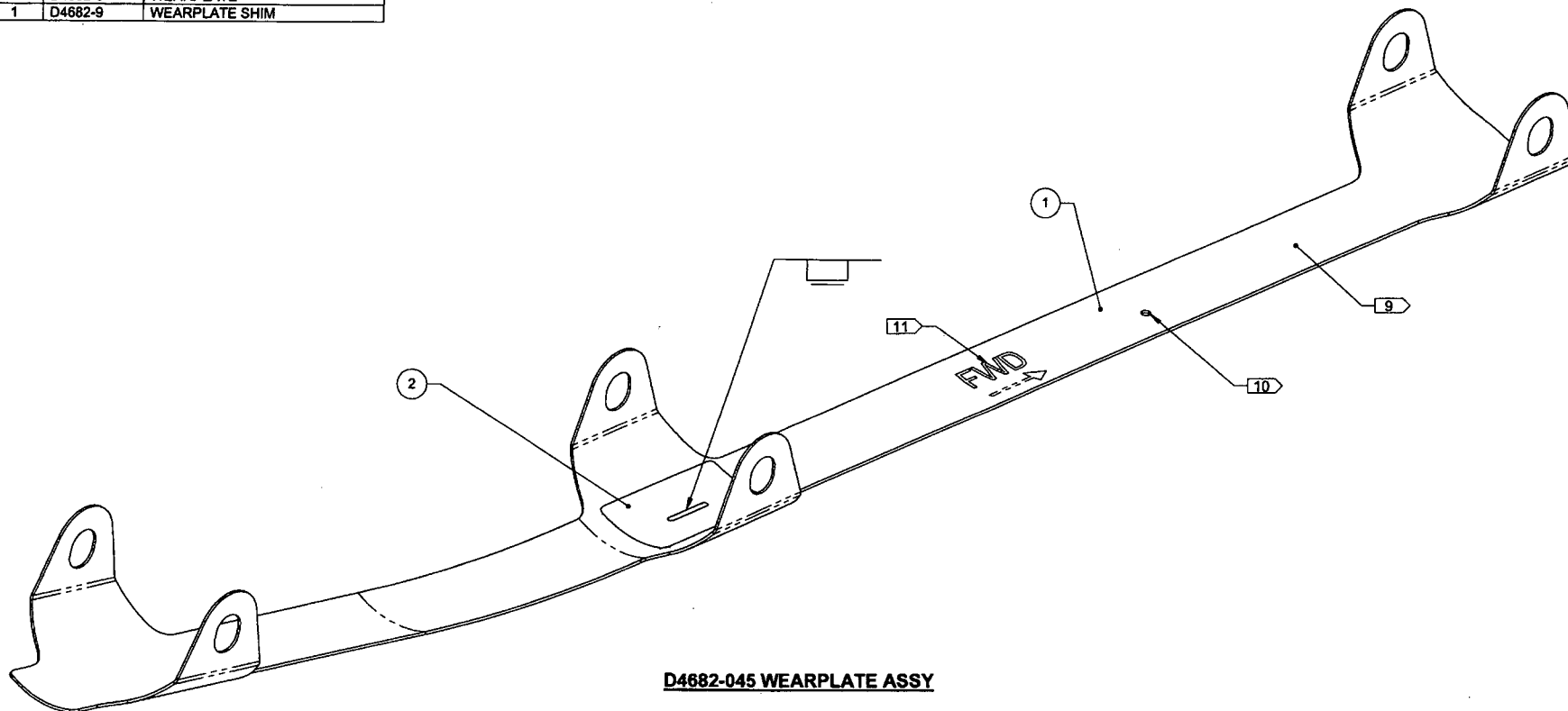
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.20 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

RELEASED
2015-06-08

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO. D4682	REV. D
	MFG. APPR.	DD	SHEET 2 OF 8	
	APPROVED	HS	TITLE WEARPLATE ASSY	SCALE NTS
	DE APPR.	DS	DATE 15.03.24	

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ITEM	QTY	P/N	DESCRIPTION
	X	D4682-045	WEARPLATE ASSY
1	1	D4682-5	WEARPLATE
2	1	D4682-9	WEARPLATE SHIM



D4682-045 WEARPLATE ASSY

NOTES:

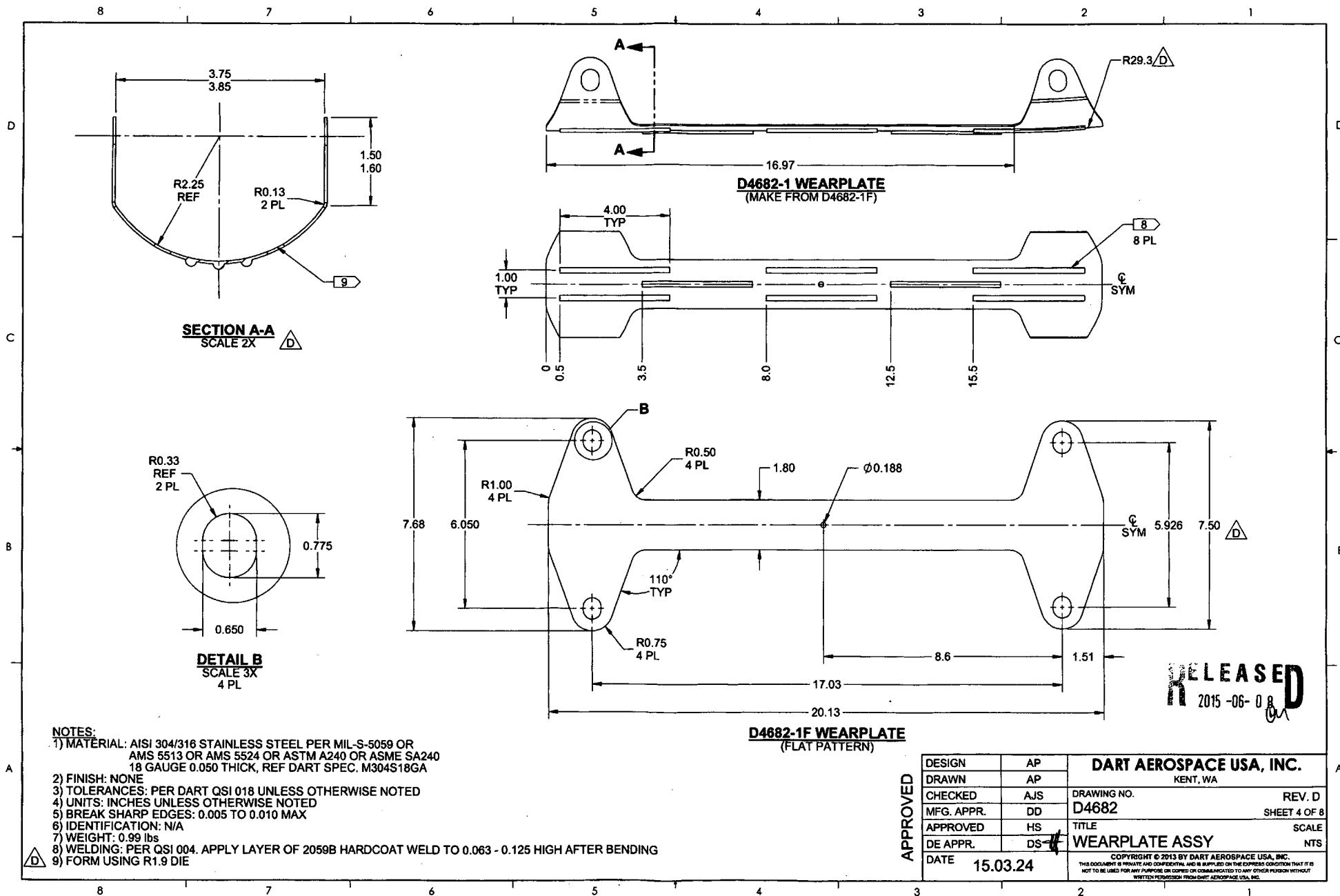
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 1.85 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER



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2015-06-08

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DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
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MFG. APPR.	DD	D4682	SHEET 3 OF 8
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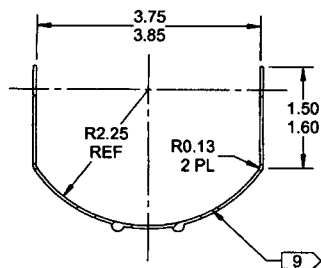


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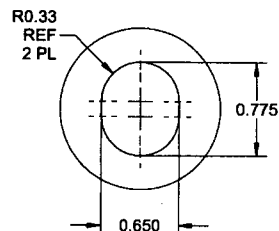
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR
AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.12 lbs
- 8) WELDING: PER QSI 004. APPLY LAYER OF 2059B HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) FORM USING R1.9 DIE

RELEASE
2015-06-08

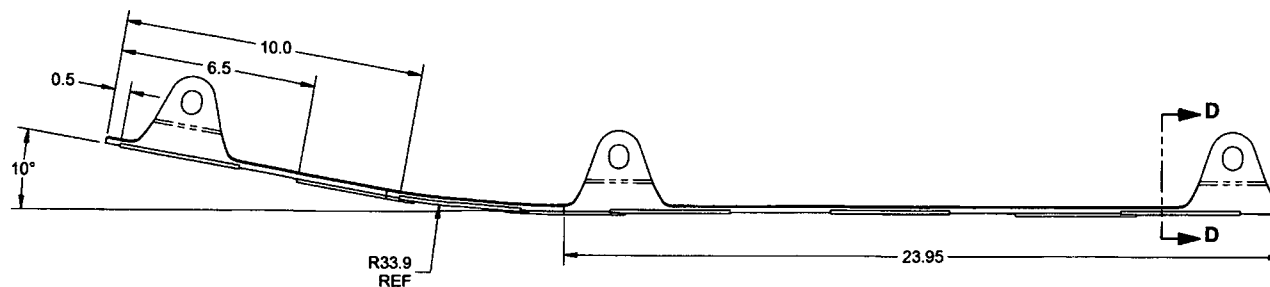
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DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4682	SHEET 5 OF 5
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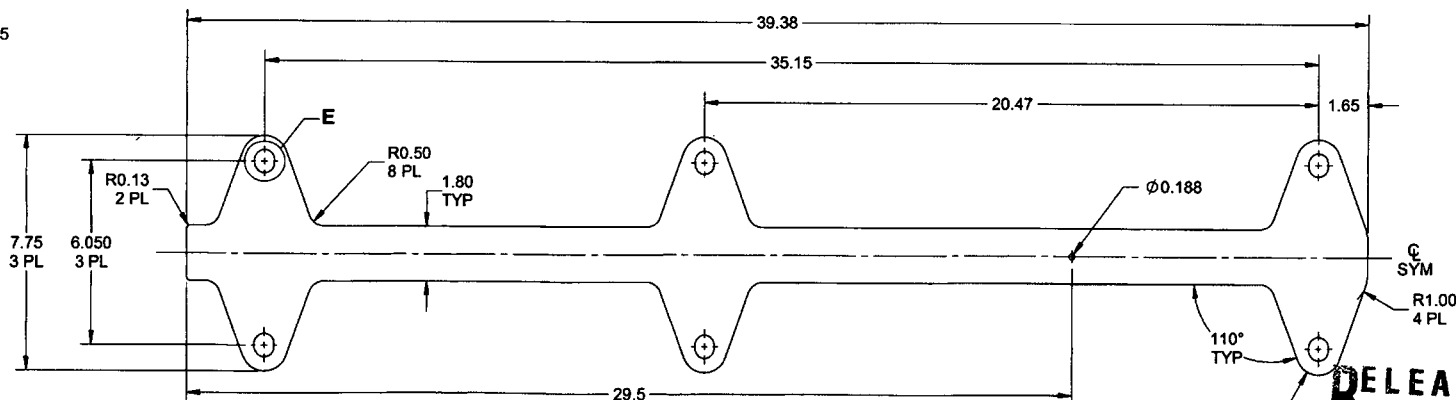
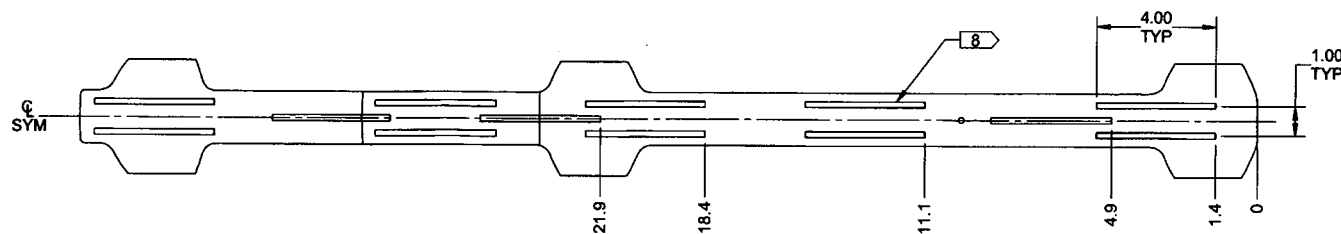
SECTION D-D
SCALE 2X



DETAIL E
SCALE 4X
6 PL



D4682-5 WEARPLATE
(MAKE FROM D4682-5F)



D4682-5F WEARPLATE
(FLAT PATTERN)

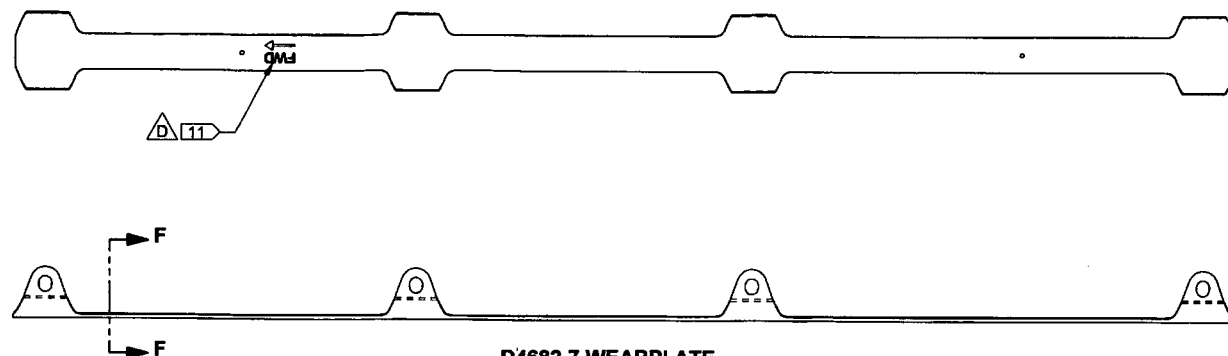
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) WELDING: PER QSI 004. APPLY LAYER OF 2059B HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
- 9) FORM USING R1.9 DIE

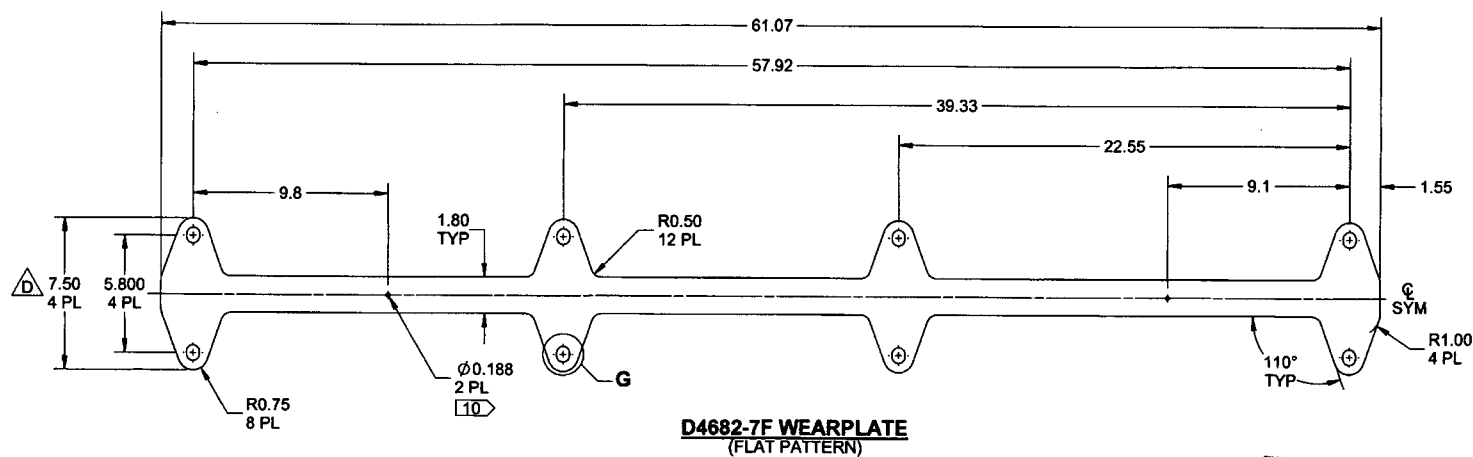
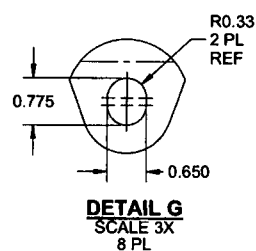
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CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4682	SHEET 6 OF 8
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RELEASED
2015-06-08



D4682-7 WEARPLATE
(MAKE FROM D4682-7F)



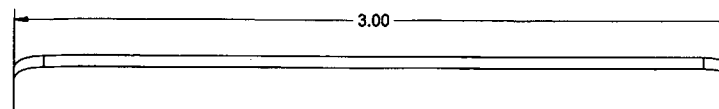
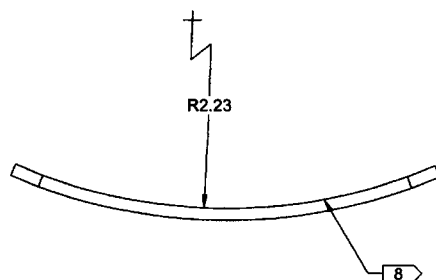
D4682-7F WEARPLATE
(FLAT PATTERN)

RELEASED
2015-06-08

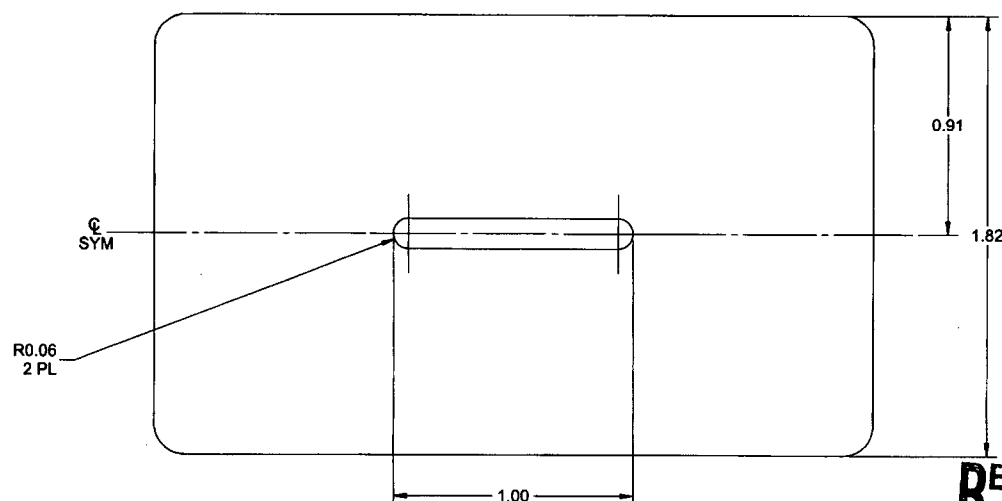
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR
AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.28 lbs
- 8) FORM USING R1.9 DIE
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING,
0.020-0.040 THICK AFTER BENDING PER QSI 005 SECTION 4.9
- 10) OPEN UP DRAIN HOLE IF NECESSARY TO Ø0.188 AFTER APPLYING TEXTURED COATING
- 11) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. 0
MFG. APPR.	DD	D4682	SHEET 7 OF 7
APPROVED	HS	TITLE	SCALE
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D4682-9 WEARPLATE SHIM
(MAKE FROM D4682-9F)



D4682-9F WEARPLATE SHIM 
(FLAT PATTERN)

RELEASED
2015-06-08

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs
- 8) FORM USING R1.9 DIE

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D4682	SHEET 8 OF 8
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